

Date: Wednesday, 27/08/2008 12:54:26 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BO 105 SKIDTUBE ASSEMBLY
Job Number :	41640		
Estimate Number :	10112		
P.O. Number :		Part Number :	D105674011G
This Issue :	27/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2966 REV A2
First Issue :	/ /	Project Number :	N/A
Previous Run :	41639	Drawing Revision :	A2
	Type :	Material :	
	SKIDTUBES	Due Date :	10/09/2008
Written By :		Qty:	1
Checked & Approved By :	JLD 08.8.24	Um:	Each
Comment :	Est Rev:A 04.07.07 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.8.28



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP d105-674-011G CHG002

2.0	D2962125	Outer Tube Extrusion
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion B17532

RT 08-08-27

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

RT 08-08-27

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

RT 08-08-27

5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

RT 08-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41640

Part Number: D105674011G

Grey

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut Aft end at 107.06" using DT8185D

3-Deburr ends

4-Drill Aft Cap holes using DT8678

5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

7-Open Aft Cap holes using #6 drill

8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg

D2966-1.

9-Deburr holes.

10-Open remaining (16) crossbolt holes to Ø0.500

RT
06-08-29

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2964

Cap

14101

A/R

Aluminum Rod

m108708/m107877

BE 08-09-02

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.

BE 08-09-02

2-Grind Fwd Cap welds flush

LT 08-09-02

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/09/02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/02 (40)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

25 08-09-02

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11 8-9-2

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966

3-Deburr holes inside & outside, blow out chips

25 08-09-02

13.0

D2976

BO 105 Skidtube I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Numbe

Description Batch

1 D2976 Web

B-41668

AWM
8-9-2

14.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2971 Crossbolt Spacer

B3901/BE8-9-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2973

Cross Bolt Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2973 Crossbolt Spacer

B14636 BE 8-9-3

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date:

*M108601
8-10-01*

*- AWM
8-2-2*

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M108708 BE 8-9-3

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

BE 8-9-3

4-Grind welds flush as per Dwg D2966

JD 8-9-4

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/09/05

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/05

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



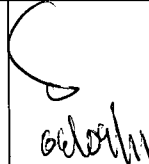
Comment: HAND FINISHING RESOURCE #1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

pressure wash M106442

FR 08/09/05

(P10) →

W/O: 41640		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/09/08	19.0	start time: 8:40 Temp: 320° Finish time: 9:10	FL	08/09/08	①		
		Perment change	BE	08-09-15			
		ESTIMATE # 10112					

Part No: D105-674-011G PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-09

(XV)

21.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2965

Cap

B41885

m.d

22.0

D29701

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-1

Wearplate

B33220

m.d

23.0

D29703

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2970-3

Wearplate

B12322

~~B12322~~

~~B14590~~

m.d

24.0

D31761

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-1

Bushing

B33222

m.d

25.0

D31763

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3176-3

Nut

B37585

m.d

08/09/09

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

ALS71032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

36 ALS7-1032-130 Insert

or ALS4-1032-130

or AKS7-1032-130

or AKS4-1032-130

M105819

[Handwritten mark]

M-h

27.0

AN960JD10L

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 AN960JD10L Washer

M105793

M-h

28.0

MS27039108

Screw



Comment: Qty.: 26.0000 Each(s)/Unit Total: 26.0000 Each(s)

Pick:

Qty Part Number Description Batch

26 MS27039-1-08 Screw

M109061

M-h

29.0

MS27039109

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-09 Screw

M18057

M-h

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for foreign objects as per QSI 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

M-h 08/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expiry date:

M108443

08/11

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch: M107892

08-07-09 (V)

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/09/09 (X)

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/09 (X)

*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

34.0

D2972

Bushing



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

6 D2972

Bushing

B314103 (X)

08/09/11 (X)

35.0

D2974

Packer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2974

Packer

34249

08/09/11 (X)

36.0

D2975

Wearshoe



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2975

Wearplate

34234

08/09/11 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 41640

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/12
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-11

B41640

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



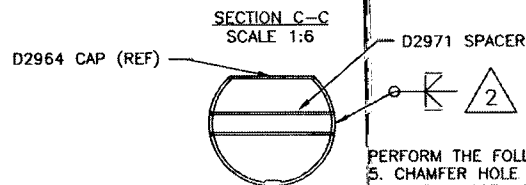
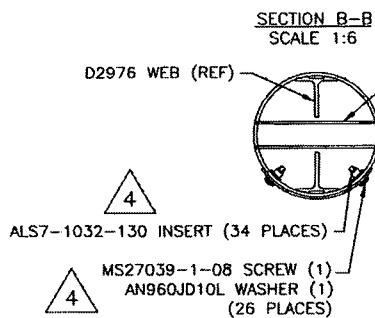
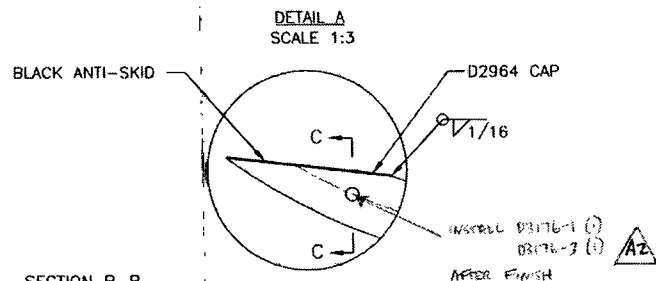
01.01.24
CP 01.01.30

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

A2	02.10.30	ADD D3176-1/-3	# CP
A1	01.01.24	CHANGE COLOR TO BLACK SANDTEX	# CP

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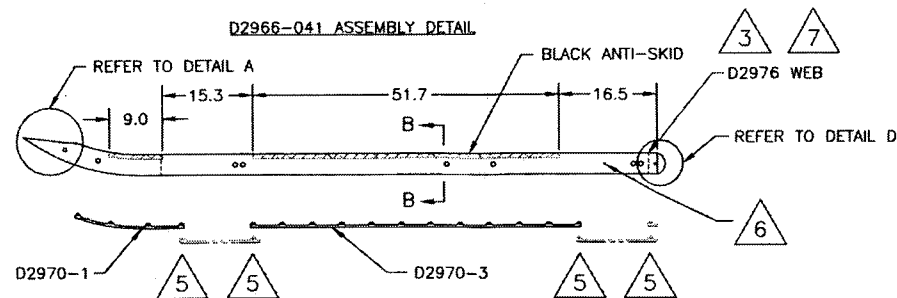
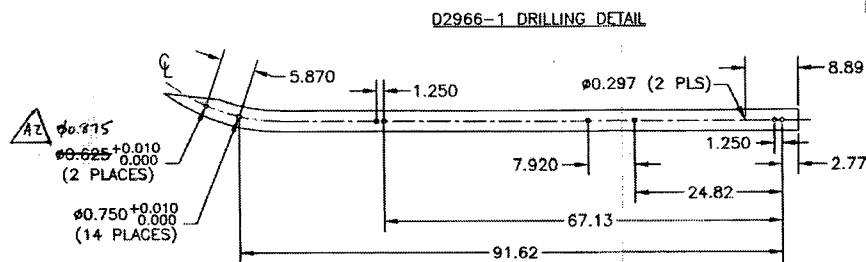
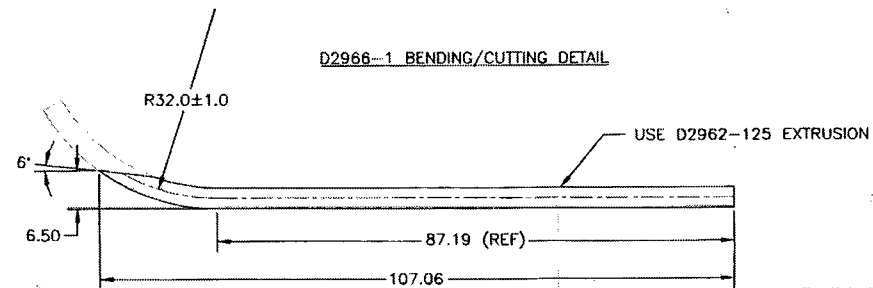
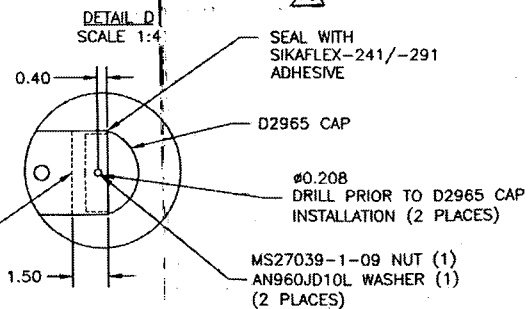


AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:

1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2973 SPACER (7 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

PERFORM THE FOLLOWING FOR $\phi 0.625$ HOLES ONLY:

5. CHAMFER HOLE $0.030 \times 45^\circ$
6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER



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	CHECKED A	APPROVED A		
	DATE 00.03.08	DRAWING NO. D2966		
	TITLE BO 105 SKIDTUBE ASSEMBLY			

NO. 21640

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
00-05-11

NO. 172

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 41331
Part number: B0105 674 011
Description: B0105 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Ed Dwyer  Date of Test Coupon 08-09-05

Welder Barclay Elliot  Date of Test Coupon 08-09-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld